

SPUR ~~STL 10/09~~

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: PILOT/CO-PILOT STEP, RH (FOLDING)		
Job Number	: 41778			Part Number	: D412630032		
Estimate Number	: 10824			Drawing Number	: IIN D412-630		
P.O. Number	:			Project Number	: N/A		
This Issue	: 03/09/2008	S.O. No.	:	Drawing Revision	: L		
Prsht Rev.	: NC			Material	:		
First Issue	: 03/09/2008	Type	: SMALL /MED FAB	Due Date	: 10/10/2008		
Previous Run	: 41660			Qty:	/ Um: Each		
Written By	:						
Checked & Approved By	: <u>JLD 08.9.03</u>						
Comment	: EST. REV. A 05.11.21 NEW ISSUE EC						
	EST. REV. B 05.12.19 updated pick list EC						
	EST. REV.C 07.11.12 ecn 1019, nochg EC						
	verifiedby:DD						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	DC	DOCUMENT CONTROL		
	Comment: DOCUMENT CONTROL			
	Photocopy D412-630 bluefile & type labels per PPP412-630-031 CHG001			<u>Solve 10</u>
2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1		
	Comment: SMALL & MEDIUM FAB RESOURCE 1			
	Assemble as per dwg D412-630 p.17			
	****ensure tension to retract step is 11 to 18 lbs before installing lockwire.****			<u>EP 08/09/10 C</u>
3.0	D3463042	Step Weldment Assembly		
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)			
	Pick:			
	Qty	Part Number	Description	Batch
	1	D3463-042	Step weldment	<u>B41664</u>
4.0	D3443043	Strut Weldment Assembly		
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)			
	Pick:			
	Qty	Part Number	Description	Batch
	1	D3443-043	Strut ass'y	<u>B337089</u>
				<u>8/9/9</u>
				<u>54</u>

Date: Wednesday, 03/09/2008 11:30:39 AM
User: Julie Lecocq

Process Sheet

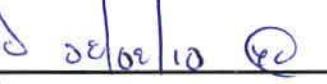
Customer: CU-DAR001 Dart Helicopters Services			Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING)
Job Number: 41778			Part Number: D412630032
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
5.0	D3443041	Strut Weldment Assembly	
	Comment: Qty.: 1.0000 Each(s)/Unit	Total : 3.0000 Each(s)	
	Pick:		
	Qty	Part Number	Description
	1	D3443-041	Strut ass'y
6.0	D34439	Pin	
	Comment: Qty.: 2.0000 Each(s)/Unit	Total : 6.0000 Each(s)	
	Pick:		
	Qty	Part Number	Description
	2	D3443-9	Pin
7.0	AN4CH3	SS Bolt	
	Comment: Qty.: 2.0000 Each(s)/Unit	Total : 6.0000 Each(s)	
	Pick:		
	Qty	Part Number	Description
	2	AN4CH3	BOLT
	A/R	MS20995c41e	Lockwire
8.0	AN4C14	BOLT	
	Comment: Qty.: 1.0000 Each(s)/Unit	Total : 3.0000 Each(s)	
	Pick:		
	Qty	Part Number	Description
	1	AN4C14	BOLT
9.0	D34547	Bushing	
	Comment: Qty.: 2.0000 Each(s)/Unit	Total : 6.0000 Each(s)	
	Pick:		
	Qty	Part Number	Description
	2	D3454-7	Bushing

Date: Wednesday, 03/09/2008 11:30:39 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services			Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING)
Job Number: 41778			Part Number: D412630032
Job Number: 			
Seq. #:	Machine Or Operation:		Description :
10.0	AN3104	NUT	
Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)			
Pick: Qty Part Number Description Batch			
2	AN310-4	Nut	M107139
11.0	MS24665227	COTTER PIN	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)			
Pick: Qty Part Number Description Batch			
1	MS24665-227	COTTER PIN	M109174
12.0	D34551	Spacer	
Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)			
Pick: Qty Part Number Description Batch			
2	D3455-1	Spacer	B30226
13.0	D34651	Washer	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)			
Pick: Qty Part Number Description Batch			
1	D3465-1	Washer	B41692
14.0	AN3107	NUT	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)			
Pick: Qty Part Number Description Batch			
1	AN310-7	Nut	M103286

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services			Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING)
Job Number: 41778			Part Number: D412630032
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
15.0	MS24665302	Cotter Pin  (X)	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s) Pick: Qty Part Number Description Batch 1 MS24665-302 COTTER PIN <u>M106763</u> 8/9/9 sf			
16.0	QC5	INSPECT WORK TO CURRENT STEP 	
Comment: INSPECT WORK TO CURRENT STEP ****ensure tension to retract step is 11 to 18 lbs **** Test fit on aircraft in Eng. lab.  S 3802 10 40			
17.0	PACKAGING 1	PACKAGING RESOURCE #1 	
Comment: PACKAGING RESOURCE #1 Pick Packing Kit			
18.0	D34541	Bushing 	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s) Pick: Qty Part Number Description Batch 1 D3454-1 Bushing <u>15337-30</u> sf			
19.0	D34543	Bushing 	
Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s) Pick: Qty Part Number Description Batch 2 D3454-3 Bushing <u>25171</u> sf			
20.0	D34545	Bushing 	
Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s) Pick: Qty Part Number Description Batch 2 D3454-5 Bushing <u>34842</u> sf			

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING)

Job Number: 41778

Part Number: D412630032

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

D34551

Spacer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:

SP
Qty Part Number Description
6 D3455-1 Spacer

Batch

B30226

SP

22.0

D34553

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

S
Qty Part Number Description
2 D3455-3 Spacer

Batch

B30227

SP

23.0

D3462042

Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

S
Qty Part Number Description
1 D3462-042 Bracket ass'y

Batch

B35860

SP

24.0

AN3104

NUT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

S
Qty Part Number Description
1 AN310-4 Nut

Batch

M107139

SP

25.0

AN3105

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

S
Qty Part Number Description
2 AN310-5 Nut

Batch

M105280

8/9/9

SP

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services			Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING)
Job Number: 41778			Part Number: D412630032
Job Number: 			
Seq. #:	Machine Or Operation:		Description :
26.0	AN3C5A	Bolt	
Comment: Qty.: 3.0000 Each(s)/Unit Total : 9.0000 Each(s)			
S Pick:			
Qty	Part Number	Description	Batch
3	AN3-C5A	Bolt	<u>M108144</u>
			SP
27.0	AN44C12	eyebolt	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)			
S Pick:			
Qty	Part Number	Description	Batch
1	AN44-C12	Eyebolt	<u>M107923</u>
			SP
28.0	AN4C15	BOLT	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)			
S Pick:			
Qty	Part Number	Description	Batch
1	AN4C15	BOLT	<u>M103248</u>
			SP
29.0	AN5C11	BOLT	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)			
S Pick:			
Qty	Part Number	Description	Batch
1	AN5C11	BOLT	<u>M103248</u>
			SP
30.0	AN5C15	BOLT	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)			
S Pick:			
Qty	Part Number	Description	Batch
1	AN5C15	BOLT	<u>M105160</u>
			SP 08/09/08 (X)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING)	
Job Number: 41778		Part Number: D412630032	
Job Number:			
Seq. #: Machine Or Operation:		Description :	
31.0 AN960C10		WASHER	
			
Comment: Qty.: 7.0000 EACH(s)/Unit Total : 21.0000 EACH(s)			
Pick:			
Qty	Part Number	Description	Batch
7	AN960C10	Washer	M109148
			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)			
Pick:			
Qty	Part Number	Description	Batch
1	AN960C516	Washer	M102842
33.0 MS210433		Nut	
			
Comment: Qty.: 3.0000 Each(s)/Unit Total : 9.0000 Each(s)			
Pick:			
Qty	Part Number	Description	Batch
3	MS21043-3	Nut	M109147
34.0 MS24665227		COTTER PIN	
			
Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)			
Pick:			
Qty	Part Number	Description	Batch
2	MS24665-227	COTTER PIN	M1091741X
35.0 MS24665229		COTTER PIN	
			
Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)			
Pick:			
Qty	Part Number	Description	Batch
2	MS24665-229	COTTER PIN	190886

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING)

Job Number: 41778

Part Number: D412630032

Job Number:



Seq. #: Machine Or Operation:

Description :

36.0 NAS1515H5 Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

1

NAS1515H5

Washer

108334

AS-08/09/08 (X1)

37.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

38.0 PACKAGING 1 PACKAGING RESOURCE #1



(X)

Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-630-031

Location: _____

PPP Rev: B

8/9/10

SP

39.0 QC21 FINAL INSPECTION/W/O RELEASE



08/09/10 (X)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 08/09-10

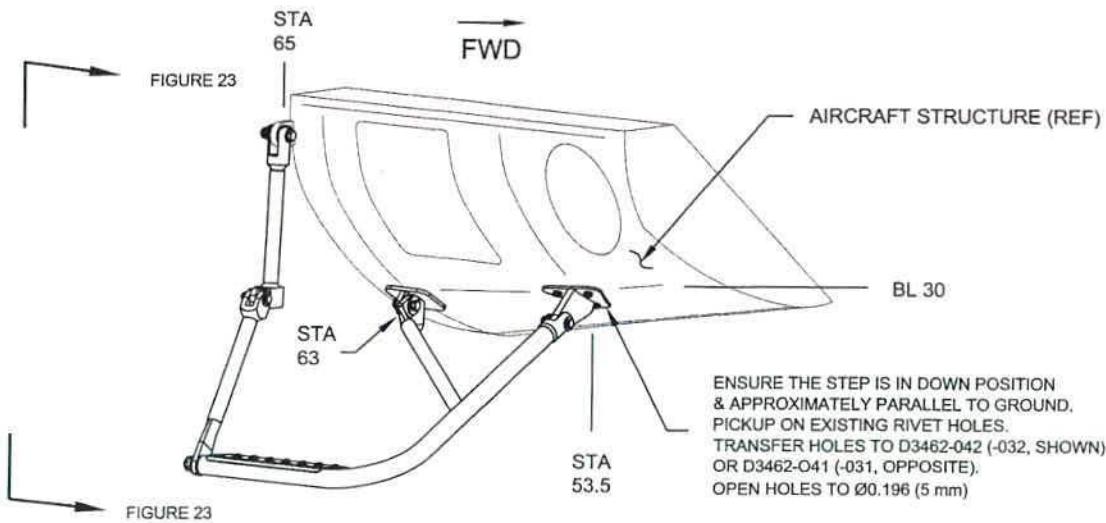
D412-630-031/-032 Pilot/Co-Pilot Folding-Step Installation

FIGURE 21 – Isometric View D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown),
D412-630-031 LH (Opposite)

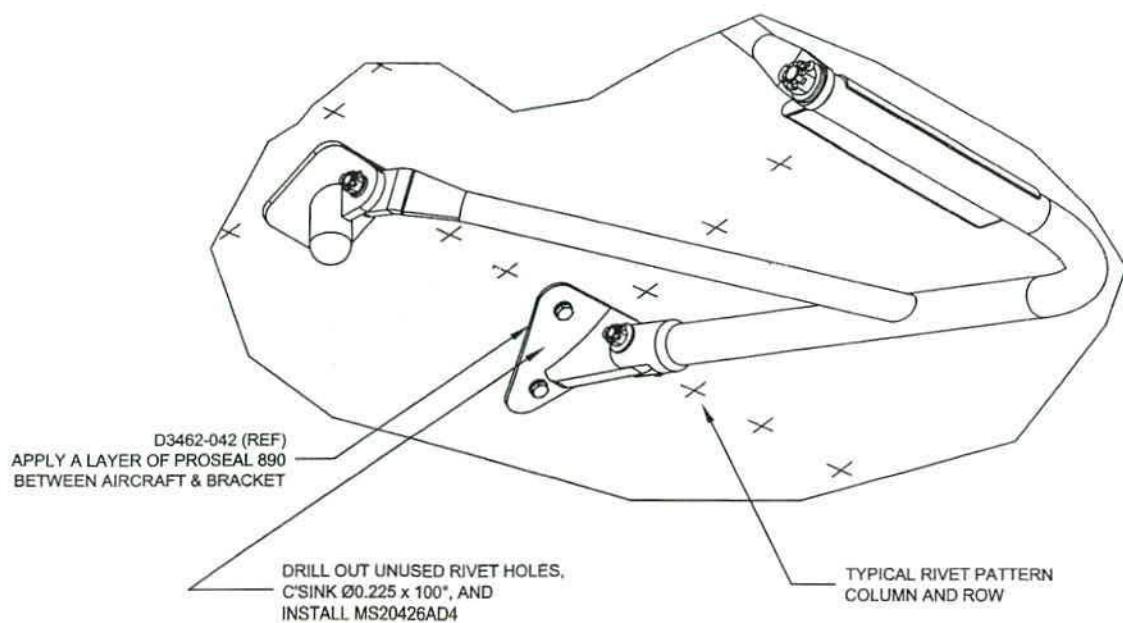


FIGURE 22 – Detail View D3462-042 Bracket Assembly (-032 Installation, Shown)
D3462-041, (-031 Installation Opposite)

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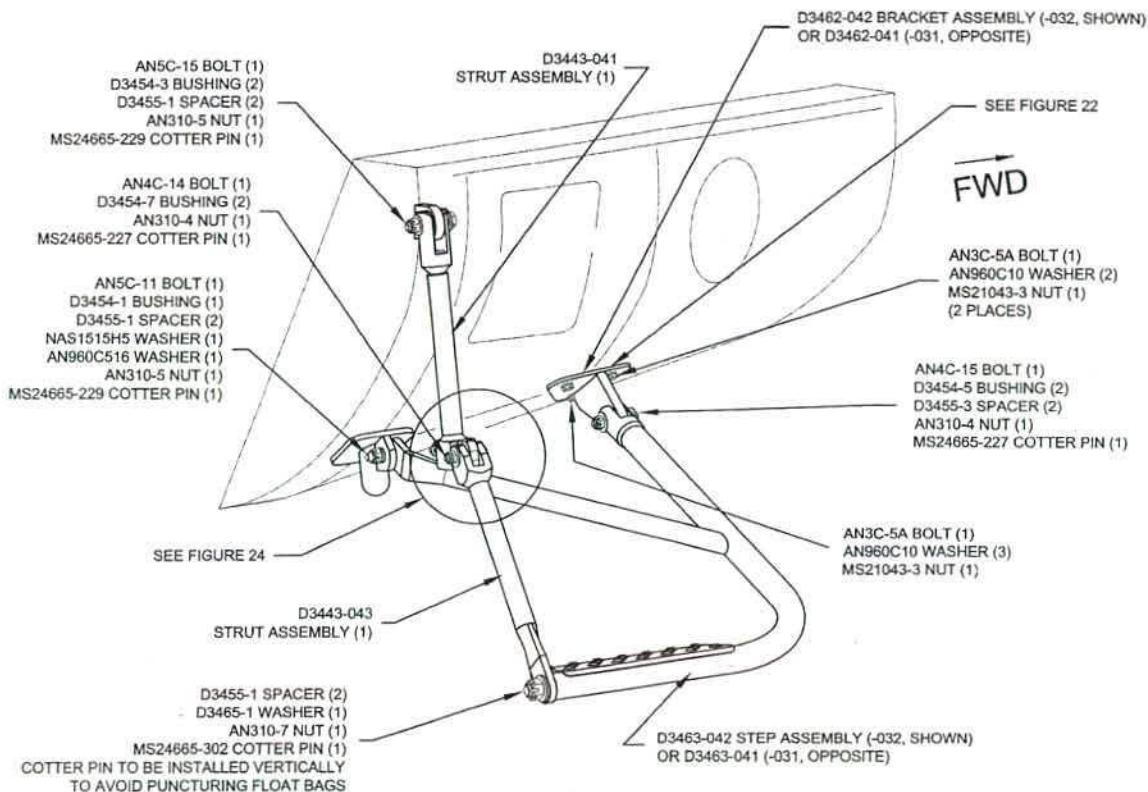


FIGURE 23 – Isometric View D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown) D412-630-031 LH (Opposite)

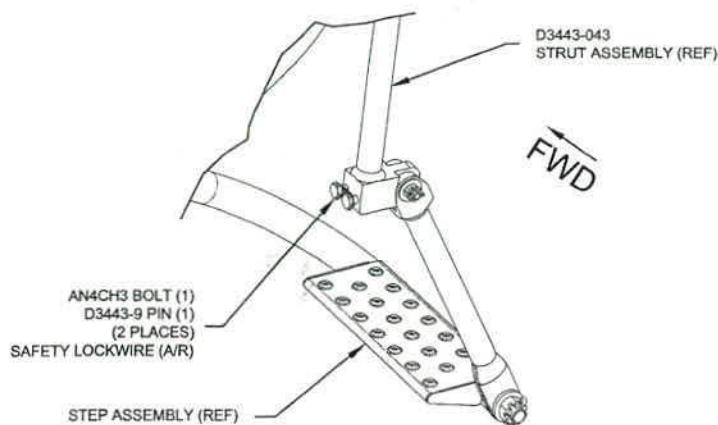


FIGURE 24 – Detail Safety Wiring, D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown) D412-630-031 LH (Opposite)

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Qty -031	Qty -032	Part Number	Description
X		D412-630-031	PILOT/CO-PILOT STEP, LH (FOLDING)
	X	D412-630-032	PILOT/CO-PILOT STEP, RH (FOLDING)
1	1	D3443-041	STRUT ASSEMBLY
1	1	D3443-043	STRUT ASSEMBLY
2	2	D3443-9	PIN
1	1	D3454-1	BUSHING
2	2	D3454-3	BUSHING
2	2	D3454-5	BUSHING
2	2	D3454-7	BUSHING
6	6	D3455-1	SPACER
2	2	D3455-3	SPACER
1		D3462-041	BRACKET ASSEMBLY
	1	D3462-042	BRACKET ASSEMBLY
1		D3463-041	STEP ASSEMBLY
	1	D3463-042	STEP ASSEMBLY
1	1	D3465-1	WASHER
2	2	AN310-4	NUT
2	2	AN310-5	NUT
1	1	AN310-7	NUT
3	3	AN3C-5A	BOLT
1	1	AN44-C12	* EYEBOLT
1	1	AN4C14	BOLT
1	1	AN4C15	BOLT
2	2	AN4CH3	BOLT
1	1	AN5C11	BOLT
1	1	AN5C15	BOLT
7	7	AN960C10	WASHER
1	1	AN960C516	WASHER
3	3	MS21043-3	NUT
2	2	MS24665-227	COTTER PIN
2	2	MS24665-229	COTTER PIN
1	1	MS24665-302	COTTER PIN
1	1	NAS1515H5	WASHER

* USE AN44-C12 EYEBOLT WHEN D412-630-031/-032 IS INSTALLED IN CONJUNCTION WITH
D412-630-023/-024™ HELI-ACCESS-STEP

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